

Work Order ID 54593

December 14, 2009 1:18:26 PM

Page 1

Item ID: D3463-7

Revision ID:

Item Name: Drag Arm

Start Date: 12/14/09

Required Date: 12/15/09

Reference:

10.00

Start Qty: 5.00

Req'd Qty: 5.00

10.00

Accept

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3463

Rev B

100



Small Fab

Small Fab

0.00

Memo

✓ 1-Cut to 13.875" 2-Deburr 3-Bend end as per dwg D3463

0.00

80 09/12/16

(10)

(10X)

09/12/15

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

2 80 09/12/16

(40)

120



Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

Memo

1-Mill as per dwg D3463 2-Drill hole & ream to 0.4385" as per dwg D3463 3-Deburr

0.00

0.00

09/12/21

10 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54593

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Page 2

Item ID: D3463-7

Revision ID:

Item Name: Drag Arm

Start Date: 12/14/09 Start Qty: 5.00

Required Date: 12/15/09 Req'd Qty: 5.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

off work 09/12/29
MAN 09/12/30

10 0

140

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

H.A 09/12/30

10 0

150

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Grind .450" rad

SAP
10-01-12

10

Pho ->

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3463-7 PAR #: N/A Fault Category: Sm. fab NCR: Yes No DQA: il Date: 10.01.19
 Resolution: acceptable Disposition: un-usable QA: N/C Closed: il Date: 10/01/26

NCR: <u>54593</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/1/12	150	Found Qty x 5 parts that are too thin from center of .435" hole to edge of flat. Should be .550", measure .522 to .537"	<u>il</u>	Parts are not good per email attached to last page.	<u>il</u> 01.10.12	<u>S</u> 10/2/14	<u>il</u> 09/2/12	<u>S</u> 10/2/12
		R.C. unable to get solid start points before drilling process.						<u>S</u> 10/2/12

NOTE: Date & initial all entries

Work Order ID 54593

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Item ID: D3463-7

Accept



Setup Start



Revision ID:

Item Name: Drag Arm

Stop



Start Date: 12/14/09 Start Qty: 5.00



Cust Item ID:

Required Date: 12/15/09 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> Siolodcy

(10)

170

Identify as per dwg & Stock Location: EL

0.00



Packaging

Memo

0.00

Packaging

10-1-14 (10) 2

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/15
MF 10-1-15

Picklist Print

December 14, 2009 1:18:25 PM

Work Order ID: 54593

Parent Item: D3463-7

Parent Item Name: Drag Arm

Comments:

Start Date: 12/14/09

Required Date: 12/15/09

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M304TR0.750W.120

Purchased

No

100

f

32.7500

5.0000

10.00 epl



304 ss round tube .750 x .120w

Cpl 10/12/15

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

32.75

111096

20

111097

12.75

Cpl 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng ^ Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

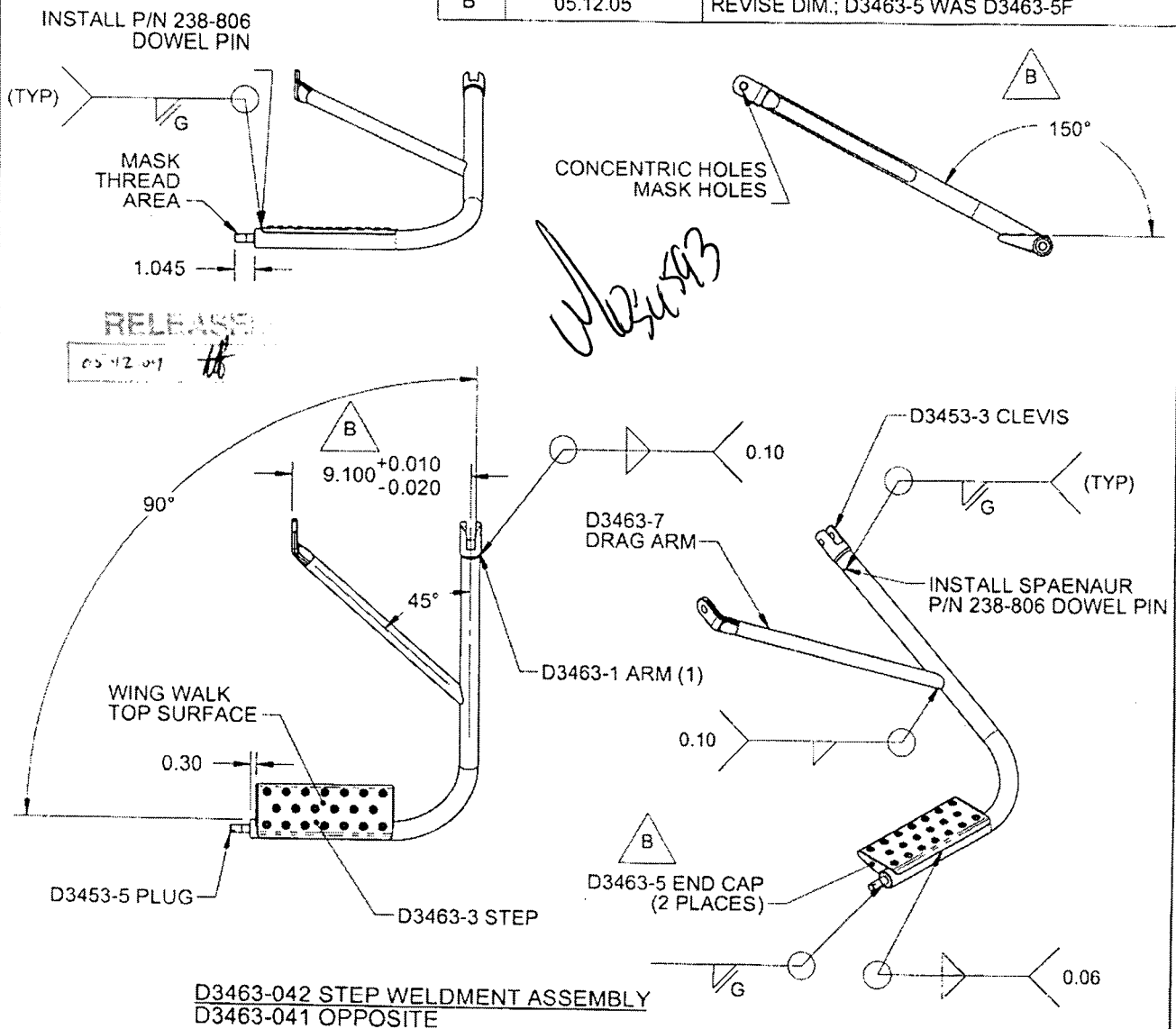
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3463	REV. B SHEET 1 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:8
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

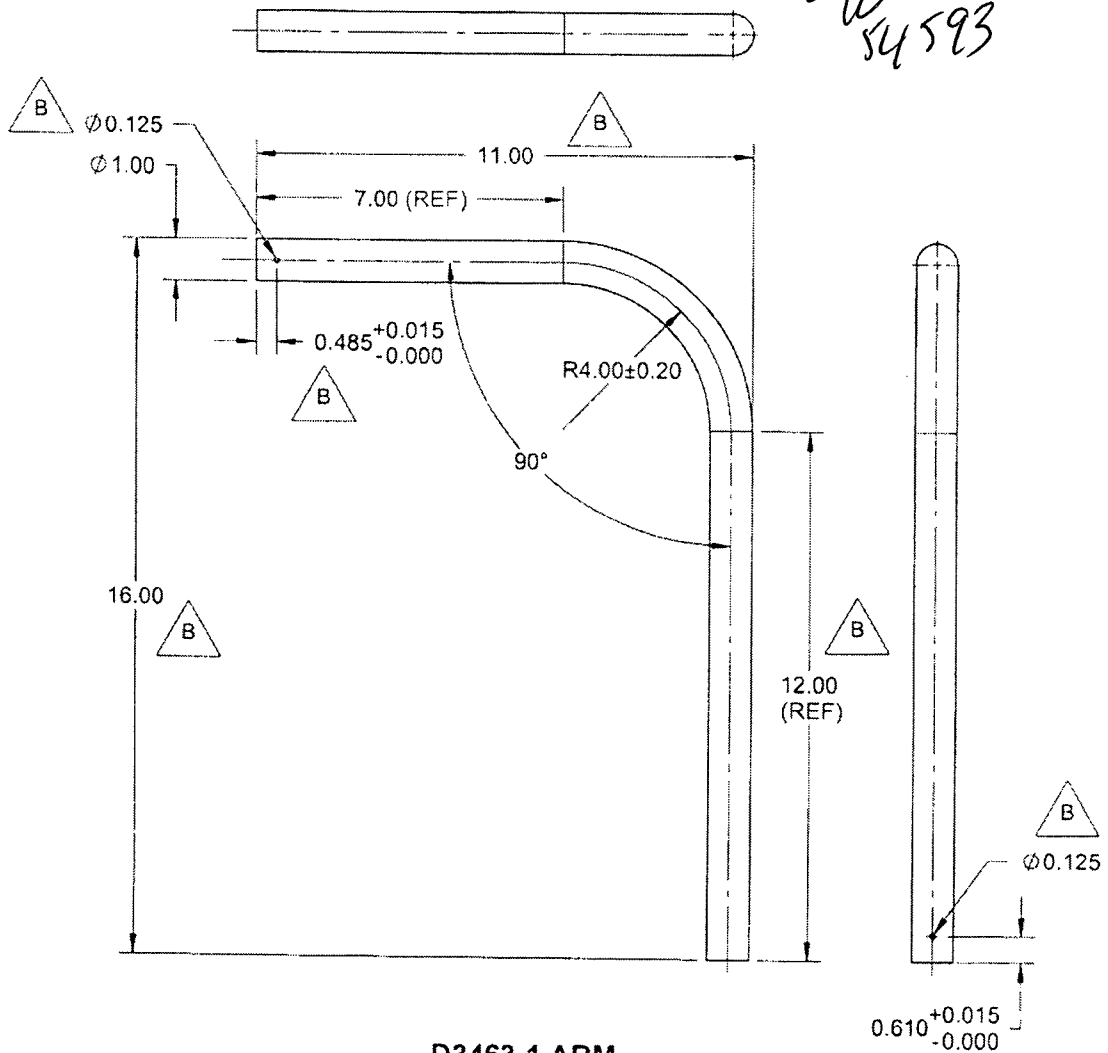
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3463	REV. B SHEET 2 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:4

RELEASED

05.12.05 *[Signature]**W*
54593**D3463-1 ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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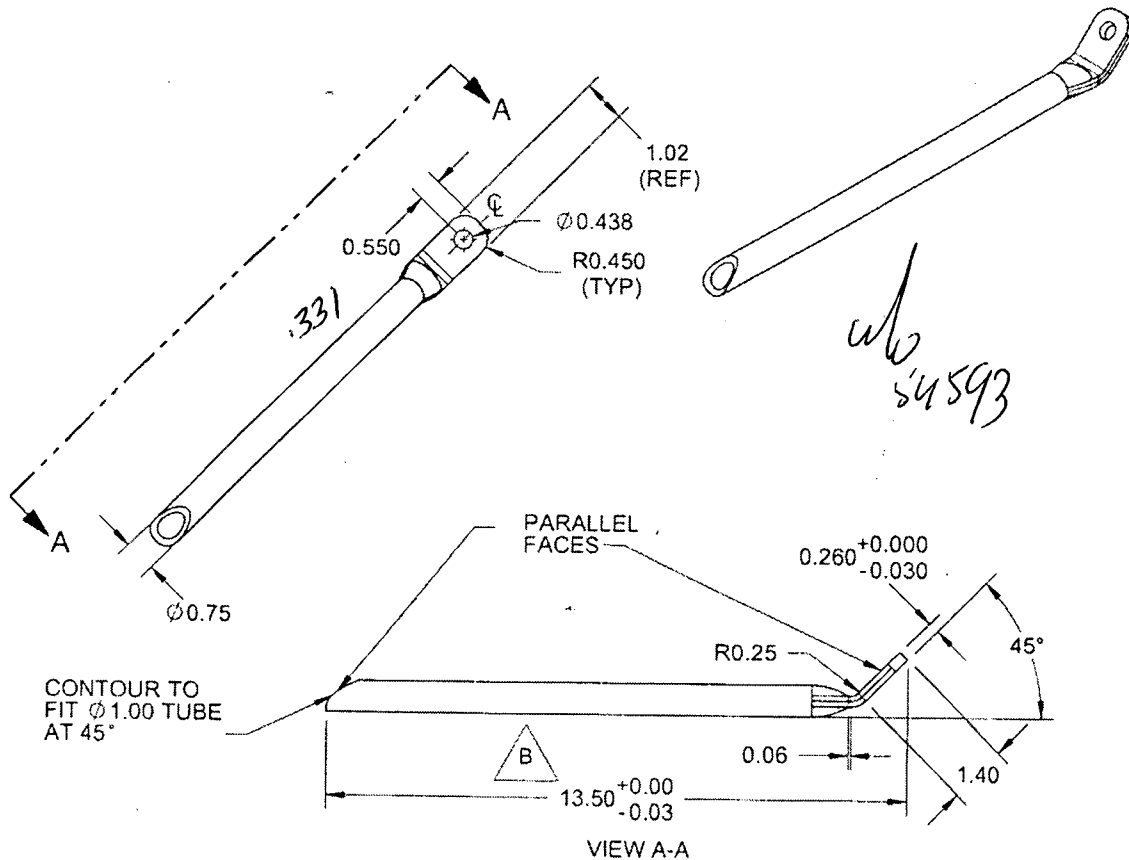
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DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 3 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:4

RELEASED

05.12.05

**D3463-7 DRAG ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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522
537

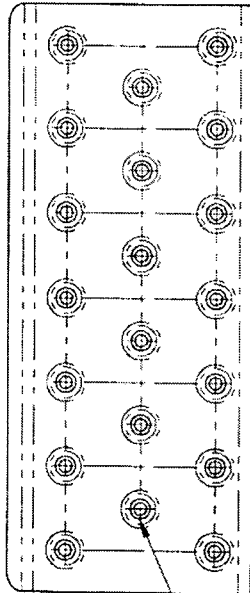
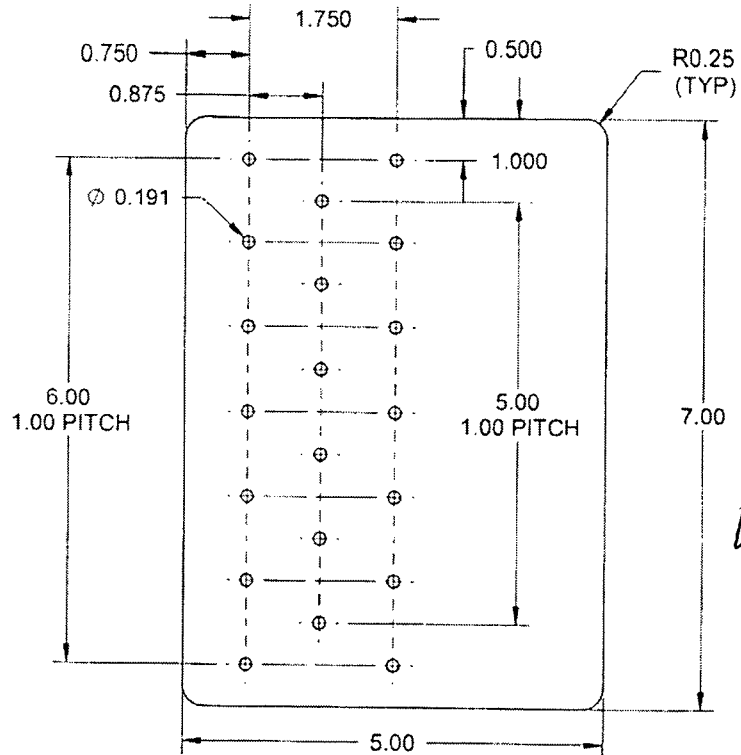
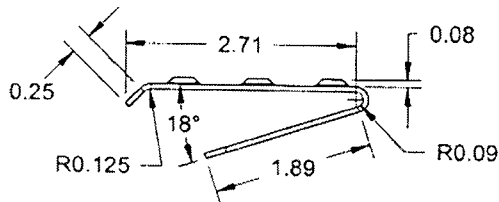
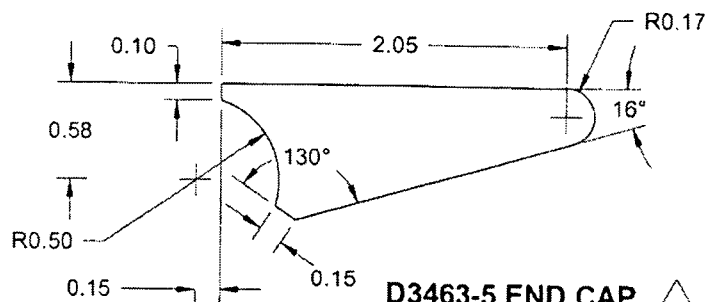
-219

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 4 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:2

RELEASED

DS.12.07 #

FORM USING
D3463-3T1**D3463-3F FLAT PATTERN****D3463-3 STEP****D3463-5 END CAP**
SCALE 1:1**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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Eric Downing

From: Roberto Fuentes [rfuentes@dartaero.com]
Sent: January 12, 2010 4:14 PM
To: 'Eric Downing'
Cc: David Shepherd
Subject: RE: D3463-7

REFERENCE ONLY

Yes it is acceptable, but make sure when D3463-7 get weld with D3463-1, the holes are concentric with D3453-3 Clevis as shown in sheet 1.

Roberto

From: Eric Downing [mailto:edowning@dartaero.com]
Sent: Tuesday, January 12, 2010 8:33 AM
To: 'Roberto Fuentes'
Cc: 'Roberto Fuentes'
Subject: D3463-7

Hello Roberto

I have QTY x5 D3463-7's with the .438" hole measuring .522" to .537" from center of hole to end of flat. Parts should be .550" from center of hole to end of flat. Are these parts good or scrap?

Eric Downing
Quality Inspector
edowning@dartaero.com